

Date: Tuesday, 15/07/2008 9:15:35 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 40494		
Estimate Number	: 10351		
P.O. Number	:	Part Number	: D30413
This Issue	: 15/07/2008 S.O. No. :	Drawing Number	: D3041 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 35979	Material	:
Written By	:	Due Date	: 15/08/2008 Qty: 40 Um: Each
Checked & Approved By	: <u>Jul 08.15.08</u>		
Comment	: Est:A 01.07.11 New Issue SM/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.1094 f(s)/Unit Total : 4.3764 f(s)
 Lug Extrusion
 (D2423) Batch: B 33310

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut D2423 Extrusion: 1.250" Long

cut @ meter

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Check for cracks while loading into the machine
 Machine as per Folio FA153 and Dwg D3041
 Tumble and Debur rough edges after tumbling
 Identify as D3041-3

machine as per drawing
D 3041 REV C.

C 20/08/07/15 (40)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

re'd + inspect for transit damage.
ensure c/c attached

15/08/08

5.0	QC2	SECOND CHECK
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Comment: SECOND CHECK

Inspect Level 5

06/08/11 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:15:35 AM
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Job Number:



Seq. #: Machine Or Operation: Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Handwritten signature

08-08-12

7.0

POWDER COATING

POWDER COATING



M108523



(40X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

START TIME:

10:20
of

OVEN TEMPERATURE:

320

FINISH TIME:

10:50

Handwritten signature

08/08/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-08-13

(40X)

9.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bearing

Pick:

Qty Part Number Description Batch

1 D2611 Bearing

B40510

08-08-14

FF

(40)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

3-Touch up stake marks with white emeron paint

FF 08-08-18

(40)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten signature

08-08-18 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:15:35 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 40494

Part Number: D30413

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 465

JS = 8/08/19 (RC)
08/08/20 JF

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-19

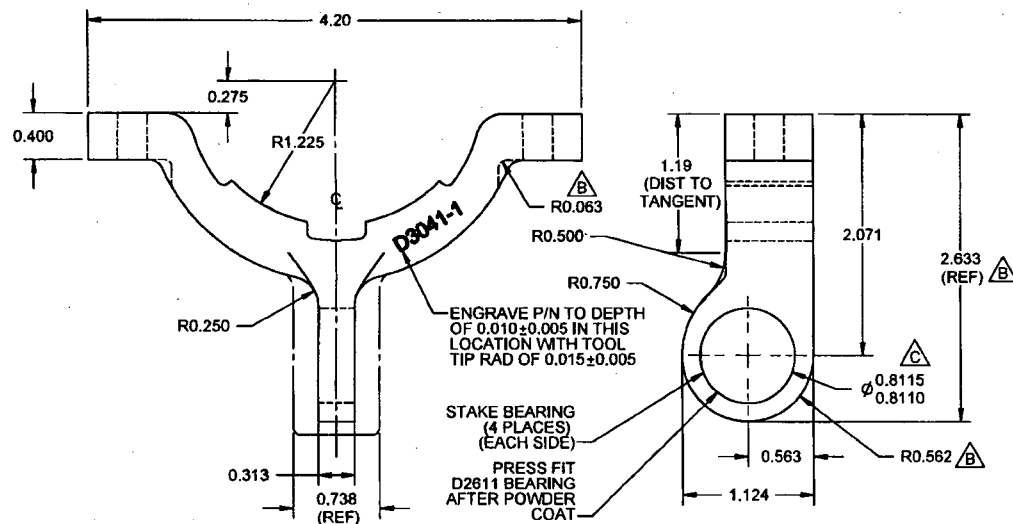
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

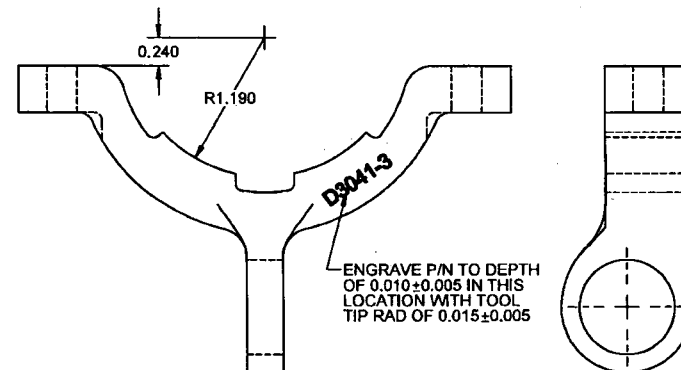
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



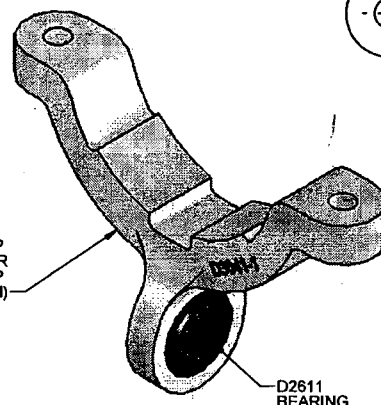
D3041-1 CLAMP



RELEASED

06.11.17

D3041-3 CLAMP
(SAME AS D3041-1
EXCEPT AS SHOWN)



D3041-1 CLAMP
(SHOWN)
D3041-3 CLAMP
(NOT SHOWN)

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) STAKE D2611 BEARING AFTER POWDER COAT
- 7) PART IS SYMMETRIC ABOUT C

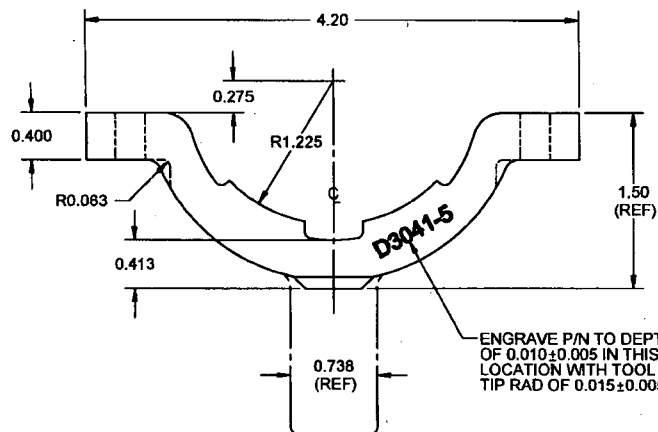
NO. 40494
WORK ORDER
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ENGINEERING
RETURN TO
SHOP COPY

C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5/-7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	06.10.18	DRAWING NO. D3041
		TITLE CLAMP
		REV. C SHEET 1 OF 2
		SCALE 1:1

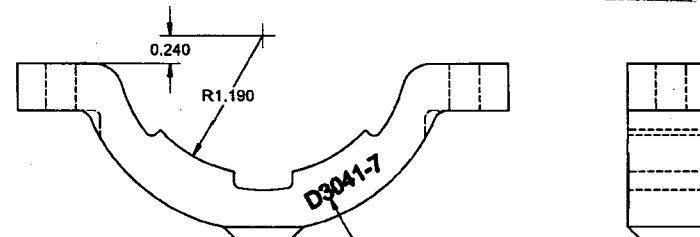
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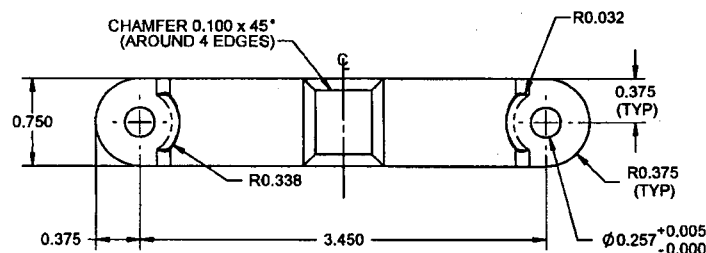
06.11.17



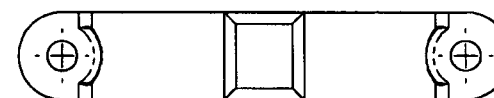
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



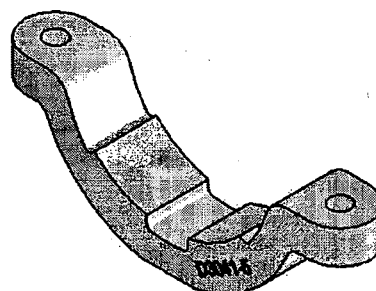
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



D3041-5 CLAMP



D3041-7 CLAMP
(SAME AS D3041-5 EXCEPT AS SHOWN)



- NOTES:
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POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
 - 6) PART IS SYMMETRIC ABOUT C

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	PORT HADLOCK, WA	
DATE	TITLE	DRAWING NO.	REV. C
06.10.18	CLAMP	D3041	SHEET 2 OF 2
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NO. 104994
WORK ORDER
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RETURN TO
SHOP COPY



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

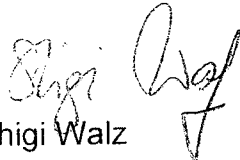
<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3041-1	Lug B40493	6776
40	D3041-3	Lug B40494	6776

MATERIAL: supplied by DART D2423 B33310

8/8/08/11

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, August 8, 2008